

131 1. (Amended) A metal-core weld wire for gas shielded welding, comprising:
a low carbon steel sheath having a carbon content of less than 0.005 % C;
a metal-core composition between approximately 16 % and approximately 20
% of a total weight of the metal-core weld wire.
5 whereby the metal-core weld wire has a relatively reduced fume generation rate.

132 3. (Amended) The metal-core weld wire of Claim 1, the total weight of the
metal-core weld wire comprises not more than approximately 0.013 % C.

133 8. (Amended) The metal-core weld wire of Claim 1, the metal-core
composition comprising not more than approximately 0.0047 % C.

134 11. (Amended) The metal-core weld wire of Claim 1, the metal-core
composition is between approximately 17 % and approximately 19 % of the total weight of
the metal-core weld wire, the metal-core composition comprising not more than approximately
0.0046 % C.

12. (Amended) The metal-core weld wire of Claim 1, the metal-core
composition comprises between approximately 17 % and approximately 19 % of a total weight
of the metal-core weld wire, and the metal-core composition comprising not more than
approximately 1.62 % Fe-Mn.

MISZCZAK ET AL.
"Ultra Low Carbon Metal-Core Weld Wire"
Atty. Docket No. 8313-60

Appl. No. 09/227,242
Examiner M. Elve
Art Unit 1725

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13. (Amended) The metal-core weld wire of Claim 12, the metal-core composition comprising not more than approximately 3.15% Fe-Si, not more than approximately 14.26 % Fe-Mn-Si, not more than approximately 0.58 % Fe-Ti, and the balance Fe powder.

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15. (Twice Amended) The metal-core weld wire of Claim 12, the metal-core composition comprising not more than approximately 0.0046 % C.

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22. (Amended) The metal-core weld wire of Claim 21, the metal-core composition between approximately 17 % and approximately 19 % of the total weight of the metal-core weld wire, the metal-core composition comprising not more than approximately 0.0046 % C based on the total weight of the metal-core weld wire.

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26. (Amended) The metal-core weld wire of Claim 21, the metal-core composition comprising not more than approximately 1.56 % Fe-Mn.

27. (Amended) The metal-core weld wire of Claim 26, the metal-core composition comprising not more than approximately 3.60% Fe-Si, not more than approximately 16.30 % Fe-Mn-Si, not more than approximately 0.66 % Fe-Ti, and the balance Fe powder.